

Date: Monday, 02/03/2009 11:23:27 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 206 GHW ADAPTER
<b>Job Number</b>	: 46160		
<b>Estimate Number</b>	: 10571		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D206651041
<b>This Issue</b>	: 02/03/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2711/D2690
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 43839	<b>Drawing Revision</b>	: A / B2
	<b>Type</b>	<b>Material</b>	:
	: SMALL / MED FAB	<b>Due Date</b>	: 27/03/2009
<b>Written By</b>	:	<b>Qty:</b>	20
<b>Checked &amp; Approved By</b>	: <u>JLD 09.03.02</u>	<b>Um:</b>	Each
<b>Comment</b>	: Est Rev: F 02.08.14 Re-format KJ Est Rev: G Removed Purchasing 07-03-21 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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*Handwritten: JLD 09/05/24*

**Comment:** DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D206-651-041 CHG001

2.0	D2692	Spring Pin Clip
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2692	Spring pin	B36682

*Handwritten: SP*

3.0	D2711	Lock Pin
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2711	Pin	B37461

*Handwritten: B 46251 (19)**Handwritten: SP*

4.0	AN960JD10	Washer
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960JD10	Washer	M110139

*Handwritten: 9/3/09**Handwritten: (20K)**Handwritten: SP*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 02/03/2009 11:23:27 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 GHW ADAPTER

Job Number: 46160

Part Number: D206651041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

CBL1240

Cable



~~M103827~~

~~107234~~



Comment: Qty.: 1.8813 f(s)/Unit Total: 37.6257 f(s)  
Cable

1107234

EP509/25/22

6.0

CBL460

Loop Sleeve



Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)  
Pick:

Qty Part Number Description Batch

2 CBL-460 Loop sleeve M109062

SP

7.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)  
Pick:

Qty Part Number Description Batch

2 MS21042L3 Nut M110399

SP

8.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)  
Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw M110552

9/3/6

SP

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut two cable CBL-1240 per assembly (10.75" each) Remove 2.25" of sleeve from each end of cable CBL-1240

2-Crimp CBL-460 onto CBL-1240 to make (2) D2690-8 as per Dwg D2690. (Leave one end open)

3-Install Lanyard D2690-8 (from open end) into pin D2711 and assemble screw, washer and nut as per Dwg D206-651.

4-Install Lanyard D2690-8 into spring pin D2692 and assemble screw, washer and nut at other loop as per Dwg D206-651.

EP509/25/22 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 206 GHW ADAPTER

Job Number: 46160

Part Number: D206651041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



lower  
(420)

Comment: INSPECT WORK TO CURRENT STEP

5 09/15/08

(20x)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



(20x)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-651-041 CHG001

Location: \_\_\_\_\_

PPP Rev: A

9/5/05

5.0

12.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

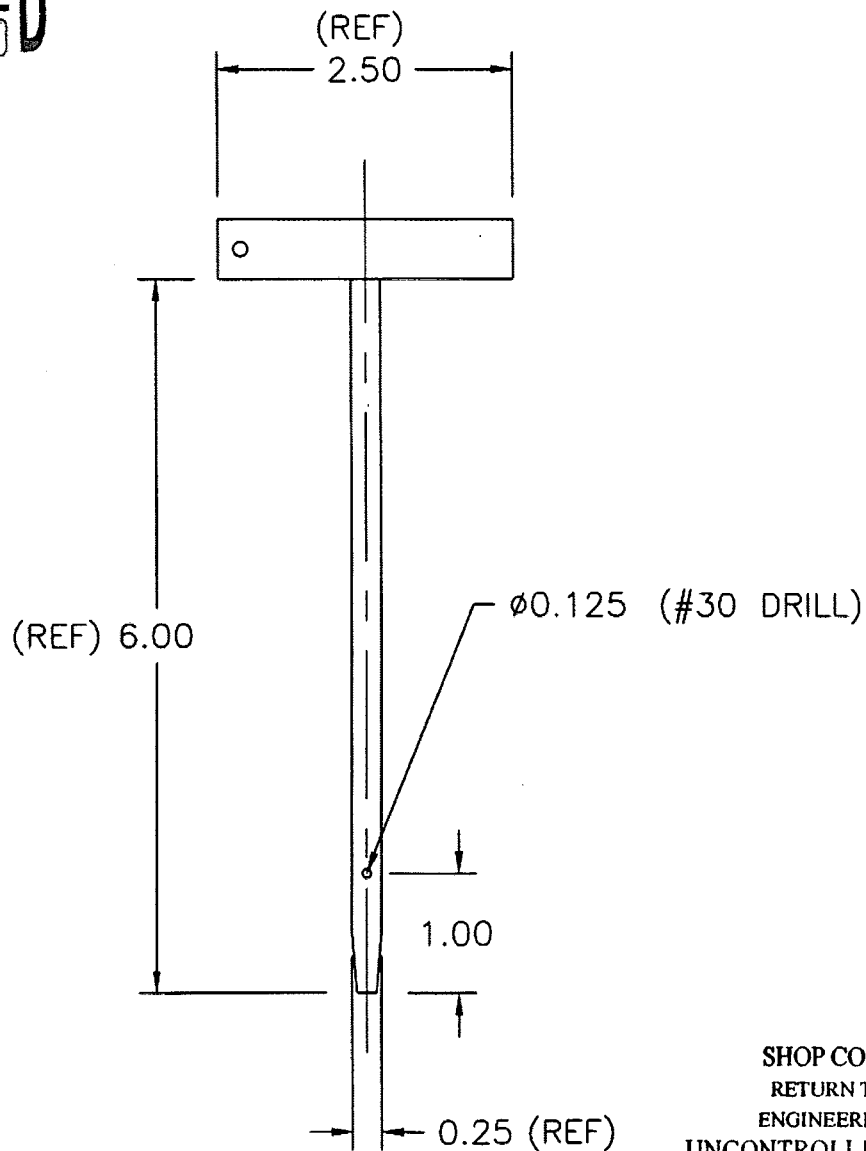
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2711	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LOCK PIN	SCALE NTS
A	97.11.03	NEW ISSUE	

RELEASED  
97/11/06 DS



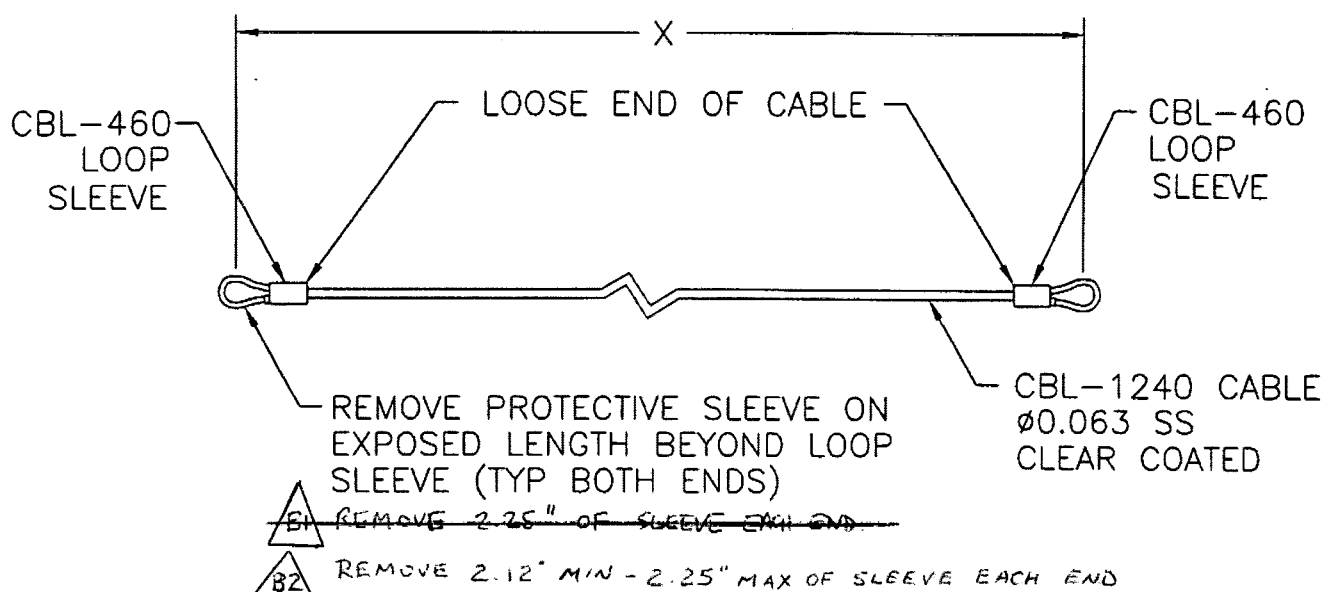
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WITHOUT NOTICE  
WORK ORDER

MAKE FROM REID TOOL SUPPLY PART # PNT-10 76160  
FINISH: CAD PLATE



DESIGN <i>ME</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>ME</i>	APPROVED <i>BW</i>	DRAWING NO. D2690	REV. B SHEET 1 OF 1
DATE 97.10.02		TITLE LANYARD ASSEMBLY	SCALE NTS
A	97.07.03	NEW ISSUE	
B	97.10.02	REVISED NOTE FOR ADDITIONAL LENGTH	
B1	<i>HCP</i> 01.08.20	ADD NOTE TO REMOVE 2.25" OF SLEEVE	
B2	<i>HCP</i> 04.06.24	ADDED TOLERANCE	

**RELEASED**  
971003 KE  
TSR A374



D2690-X

X = LENGTH IN INCHES

NOTE: CUT CABLE 2.50\* INCHES LONGER THAN 'X' LENGTH. FOLD ENDS TIGHT TO 'X' LENGTH AND CRIMP WITH SLEEVE AT END OF LOOSE END OF CABLE WITH CBL-705 CRIMPING TOOL.

\*ADDITIONAL LENGTH MAY BE NECESSARY IN SOME APPLICATIONS. CUT AS REQUIRED.

NOTE: IN SOME CASES, END HAS TO BE CRIMPED AFTER ASSEMBLY WITH ATTACHING PARTS.

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DEO's